

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D205-634-041 PAR #: _____ Fault Category: SKID LINES NCR: Yes No DQA: [Signature] Date: 10/08/10
 Resolution: Accepted Disposition: use as is QA: N/C Closed: [Signature] Date: 10/08/16

| NCR: 60742 | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|--------------------|-----------------|--|-----------------------------|---------------------------------|----------------|---------------------------|--------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 10/8/14 | # 22 | AFT key fit is not correct R.C. Process | | | | | | 10/08/10 |
| 10/8/14 | # 110.1 | AFT bend height is 1.05" Distance from AFT end to 1st hole 13.750" R.C. Bending / Process | CP 10/08/10 QD/042 | Acceptable. | N/A | [Signature] 10/08/10 | CP 10.08.10 QD/042 | 8 10/08/14 |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 60742

Thursday, July 22, 2010 8:18:17 AM

Page 3

Item ID: D205-634-041

Accept

Revision ID:

Item Name: Replacement Skidtube

Start Date: 7/21/2010 Start Qty: 1.00

Required Date: 8/6/2010 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

140

0.00

Skidtubes

Skidtubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R□□□ Aluminum Rod

M114242

BE 10/08/04

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R□□□ Aluminum Rod

M114242

BE 10/08/04

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web. Debur

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580.
Debur holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

10-8-10

| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 60742

Thursday, July 22, 2010 8:18:17 AM



Page 4

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 7/21/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 8/6/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|------------|--------|--------------|---------------|---------------|------------------|----------------|
| 150 QC Quality Control | QC10- Inspect visual per QSI004- ground welds Memo | 0.00 0.00 | S 10/08/10 | | | | | | |
| 160 QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | S 10/08/10 | | | Ⓟ | | | |
| 170 HandFinish Hand Finishing | Pressure Wash per QSI005 4.3 Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution. | 0.00 0.00 | | | | m | 10 | 08 | 11 (1) |

| W/O: | | WORK ORDER CHANGES | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 60742

Thursday, July 22, 2010 8:18:17 AM

Page 5

Item ID: D205-634-041

Accept

Revision ID:

Item Name: Replacement Skidtube

Start Date: 7/21/2010 Start Qty: 1.00

Required Date: 8/6/2010 Req'd Qty: 1.00



Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 180  Powdercoat Powder Coating | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 9:30AM OVEN TEMPERATURE: 320°F FINISH TIME: 10:00AM | 0.00 0.00 | | 101081 | | 1 | 0 | | |
| 190  QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 0.00 | | | | | | | ml 10 08 11 ① |

| W/O: | | WORK ORDER CHANGES | | | | | |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 60742

Thursday, July 22, 2010 8:18:17 AM

Page 6

Item ID: D205-634-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Replacement Skidtube

Start Date: 7/21/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 8/6/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R ☐ ☐ Sikaflex-291 ☐ 115114 ☐ ☐

Sikaflex expire date: 11/01

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R ☐ ☐ Sikaflex-291 ☐ 115114 ☐ ☐

Sikaflex expire date: 11/01

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: 115028

ml 10 08 12 ①

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 60742

Thursday, July 22, 2010 8:18:17 AM



Page 7

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 7/21/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 8/6/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|-----------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|---|
| 210 QC Quality Control | QC5- Inspect part completeness to step on W/O Memo Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024 | 0.00 0.00 | | | | | | | <u>10/08/12</u> |
| 220 Packaging Packaging | Packaging Memo Identify and pack for shipping as per PPPD205-634-041 Location: _____ PPP Rev: _____ | 0.00 0.00 | | | | | | | <u>PP 60163</u> <u>10/8/13</u> |
| 230 QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | <u>10/08/16</u> <u>C21018116</u> |

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Thursday, July 22, 2010 8:18:20 AM

Page 1

Work Order ID: 60742

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 7/21/2010



Required Date: 8/6/2010

Start Qty: 1.00



Required Qty: 1.00

Comments: IPP Rev:N02.08.28FP was QC5 in Step 27; Added QC5 to Step 30KJ
 IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM



| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|--|--|--------------|----|--|--|-----|------|--------|---|---|--|--|--|
| D2580-1 | | Manufactured | No | | | 110 | Each | 6.0000 | 1 | 1 | | | |
|  | | | | | | | | |  | | | | |
| 205 Skidtube bent detail | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| LG | 4 | |
| 57028 | 1 | |
| 59297 | 1 | |
| 60379 | 2 | |
| ST046 | 2 | |
| 59913 | 2 | |

| | | | | | | | | | | | | | |
|---|--|--------------|----|--|--|-----|------|---------|--|---|--|--|--|
| D2576-3 | | Manufactured | No | | | 140 | Each | 90.0000 | 1 | 1 | | | |
|  | | | | | | | | |  | | | | |
| Step (maching detail) | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| LG | 90 | |
| 46661 | 42 | |
| 52215 | 48 | |

| | | | | | | | | | | | | | |
|--|--|--------------|----|--|--|-----|------|----------|---|----|--|--|--|
| D2579 | | Manufactured | No | | | 140 | Each | 313.0000 | 20 | 20 | | | |
|  | | | | | | | | |  | | | | |
| Crossbolt Spacer | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| LG | 313 | |
| 57052 | 5 | |
| 57348 | 4 | |
| 58433 | 14 | |
| 59113 | 290 | |

59913
~~3-59913~~ 10-08-04
~~60379~~

1 BE 10/08/04

20 BE 10/08/04

| W/O: | | WORK ORDER CHANGES | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, July 22, 2010 8:18:20 AM

Page 2

Work Order ID: 60742

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 7/21/2010

Required Date: 8/6/2010

Start Qty: 1.00

Required Qty: 1.00

D2855

Manufactured No

200

Each

83.0000

1

1



Cap

Location

Loc Qty

Loc Code

FP6

1

56613

1

ST026

82

50513

1

50770

28

51539

2

53791

51

md 10-08-12

AN3-5A

Purchased No

200

Each

1,128.000

2

2



Bolt

Location

Loc Qty

Loc Code

ST350

1128

105057

628

115016

500

md 10-08-12

AN960JD10L

NAS1149D0332J Purchased

No

200

Each

3,021.000

2

2



Washer

Location

Loc Qty

Loc Code

ST348

3021

110985

3021

md 10-08-12

Thursday, July 22, 2010 8:18:20 AM

Shop Packet Print

Page 2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Thursday, July 22, 2010 8:18:20 AM

Page 3

Work Order ID: 60742

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 7/21/2010

Required Date: 8/6/2010

Start Qty: 1.00

Required Qty: 1.00

ALS7-1032-130

Purchased

No

200

Each

950.0000

50

50



Insert

Location

Loc Qty

Loc Code

FP

933

115079

933

ST282

17

113238

17

MM 10.08.12

AN3C4A

Purchased

No

200

Each

1,520.000

50

50



BOLT

Location

Loc Qty

Loc Code

ST350

1520

114103

501

114108

14

114416

12

114523

2

114941

991

MM 10.08.12

AN960C10L

NAS1149C0332

Purchased

No

200

Each

0.0000

50

50



washer

D3566-13

Manufactured

No

200

Each

35.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP

4

53461

4

FP012

31

59661

23

60209

8

MM 10.08.12

MM 10.08.12

Thursday, July 22, 2010 8:18:20 AM

Shop Packet Print

Page 3

| W/O: | | WORK ORDER CHANGES | | | | | |
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Picklist Print

Thursday, July 22, 2010 8:18:20 AM

Page 4

Work Order ID: 60742

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 7/21/2010

Required Date: 8/6/2010

Start Qty: 1.00

Required Qty: 1.00

D3566-5 Manufactured No

200 Each

16.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP015

16

59158

16

D3566-1 Manufactured No

200 Each

21.0000

2

2



Gasket

Location

Loc Qty

Loc Code

FP015

21

57715

2

59126

7

60202

12

D3564-11 Manufactured No

200 Each

10.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP019

10

59941

10

D3564-13 Manufactured No

200 Each

19.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP17

19

59660

19

ml 10.08.12

ml 10.08.12

ml 10.08.12

ml 10.08.12

Thursday, July 22, 2010 8:18:20 AM

Shop Packet Print

Page 4

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NOTE: Date & initial all entries

Picklist Print

Thursday, July 22, 2010 8:18:20 AM

Page 5

Work Order ID: 60742

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 7/21/2010

Required Date: 8/6/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-9

Manufactured No

200 Each

13.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP

1

55334

1

FP019

12

59201

12

D3564-5

Manufactured No

200 Each

16.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FG

1

34806

1

FP19

4

57525

1

58709

3

FP-19

11

59157

11

D2594-3

Manufactured No

200 Each

443.0000

16

16



O-Ring, 205 Skidtube

Location

Loc Qty

Loc Code

FP

443

55546

19

58191

12

59358

412

MM 10.08.12

MM 10 08.12

MM 10.08.12

Thursday, July 22, 2010 8:18:20 AM

Shop Packet Print

Page 5

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, July 22, 2010 8:18:20 AM

Page 6

Work Order ID: 60742



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 7/21/2010

Required Date: 8/6/2010

Start Qty: 1.00

Required Qty: 1.00

D2594-1

Manufactured No

200

Each

451.0000

16

16



Plug, 205 Skidtube



Location

Loc Qty

Loc Code

| | | |
|-------|-----|--|
| FP | 183 | |
| 42807 | 112 | |
| 55002 | 71 | |
| FP14 | 268 | |
| 58434 | 79 | |
| 59110 | 189 | |

MM 10-08-13

Thursday, July 22, 2010 8:18:20 AM

Shop Packet Print

Page 6

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

DART

| | | | |
|------------------|----------------|--|------------------------|
| DESIGN # | DRAWN BY RH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D2580 | REV. D SHEET 1 OF 3 |
| DATE 07.02.27 | | TITLE 205 SKIDTUBE ASSEMBLY | SCALE NTS |
| A | 96.09.16 | NEW ISSUE | |
| B | 96.12.02 | AS MANUFACTURED | |
| C | 98.08.26 | REDRAWN, INCLUDED DEO 9094/9097 | |
| D | 07.02.27 | CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183 | |

RELEASED
07.06.28 #

| QTY -041 | QTY -045 | Part Number | Description |
|-------------|-------------|---|-------------------|
| X | | D2580-041 | SKIDTUBE ASSEMBLY |
| | X | D2580-045 | SKIDTUBE ASSEMBLY |
| 1 | 1 | D2500-1-190 | EXTRUSION |
| 1 | 1 | D2576-3 | STEP |
| 20 | 24 | D2579 | CROSS BOLT SPACER |
| 16 | 16 | D2594-1 | PLUG |
| 16 | 16 | D2594-3 | O-RING |
| 1 | 1 | D2596 | 205 WEB |
| 1 | 1 | D2855 | AFT CAP |
| 1 | 1 | D3564-5 | WEARSHOE |
| 1 | 1 | D3564-9 | WEARSHOE |
| 1 | 1 | D3564-11 | WEARSHOE |
| 1 | 1 | D3564-13 | WEARSHOE |
| 2 | 2 | D3566-1 | GASKET |
| 1 | 1 | D3566-5 | GASKET |
| 1 | 1 | D3566-13 | GASKET |
| 50 | 50 | ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130 | INSERT |
| 50 | 50 | AN3C4A | BOLT |
| 2 | 2 | AN3-5A | BOLT |
| 50 | 50 | AN960C10L | WASHER |
| 2 | 2 | AN960JD10L | WASHER |

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

NO 001742-781
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHIP COPY

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NOTE: Date & initial all entries

NO. 232

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 59805
Part number: D205-634-041
Description: 205 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat. Dunn Date of Test Coupon 10.06.01
Welder Barclay Elliott Date of Test Coupon 10.06.01

The above named individual is qualified in accordance with AWS D17.1.2001 to weld